



Dart Aerospace Ltd.
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D3564-9
Job Sheet 202937



Part No: D3564-9

Job Qty: 12 pcs

Part Name: Wearplate Fwd



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/5/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		12/12/19	0.17	2.32	Waterjet - Flow		2019/11/16
120	QC 8	12 pcs		12/12/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		NOV 22 2019 40
							QC 8 - 52		9-88
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
130	Small Fab - Brake NC - B4B	12 pcs		12/12/19	0.25	0.64	Small Fab - Brake - 1 - B4B		DAS 30 9-88



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Container No: S232492



Part: D3564-9
Job No: 202937
Serial No/Batch: S232492

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Date: 12/16/19

				Small Fab - Brake - 2 - B4B	NOV 27 2019
				Small Fab - Brake - 3 - B4B	
140 QC 5	12 pcs	12/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	D/
				QC 5 - 30	4
				QC 5 - 40	NOV 29 2019 9-88
				QC 5 - 61	
				QC 5 - 81	
150 Automated Welding - B4B	12 pcs	12/12/19	0.00 4.80	Automated Welding - 1 - B4B	J.M.
160 QC 10	12 pcs	12/12/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
170 QC 5	12 pcs	12/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
180 Spray Paint - 2 - B4B	12 pcs	12/12/19	0.00 4.00	Spray Paint - 1 - B4B	DAS
				Spray Paint - 2 - B4B	41 DEC 16 2019
				Spray Paint - 3 - B4B	9-89
				Spray Paint - 4 - B4B	
190 QC 5	12 pcs	12/12/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	

					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	DEC 17 2019
					QC 5 - 61	
					QC 5 - 81	
200	Packaging 3-1 - Stock - B4B	12 pcs	12/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	BE B 19-12-17
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	12 pcs	12/12/19	0.00 0.00	QC 21 - SA - 21	DAS 21 9-89
					QC 21 - SA - 70	DEC 17 2019
					QC 21 - SA - 53	
					Broussard	

Part Op 100 - 1-Cut as per DWG. DWG. Rev: E PROG. Rev: E 2-Deburr if necessary
Descriptions: 120 - (QC8- Inspect parts - second check)
130 - (Form as per dwg)
140 - (QC5- Inspect part completeness to step on W/O)
150 - (Automated welding) 8259-M/39025

DAS
82
9-89

DAS
40
9-89

- 160 - (QC10- Inspect visual per QSI004- ground welds)
- 170 - (QC5- Inspect part completeness to step on W/O)
- 180 - TEXTURE COAT BATCH: 5235921
- 190 - (QC5- Inspect part completeness to step on W/O)
- 200 - (Identify as per dwg & Stock Location: FP002)
- 210 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	16.9200 sf (1.41 ea)	100-Waterjet - Flow - 1	<u>S207058</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	17	275	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	3.227inches ± 0.010	3.237 3.217		
2	Wearshoe	2.432inches ± 0.010	2.442 2.422		
3	Wearshoe	2.500inches ± 0.030	2.530 2.470		
4	Wearshoe	6.000inches ± 0.010	6.010 5.990		
5	Wearshoe	12.104inches ± 0.010	12.114 12.094		
6	Wearshoe	18.000inches ± 0.010	18.010 17.990		
7	Wearshoe	18.000inches ± 0.010	18.010 17.990		
8	Wearshoe	18.000inches ± 0.030	18.030 17.970		
9	Wearshoe	9.000inches ± 0.030	9.030 8.970		
10	Wearshoe	11.500inches ± 0.030	11.530 11.470		
11	Wearshoe	0.300inches ± 0.010	0.310 0.290		
12	Wearshoe	0.300inches ± 0.010	0.310 0.290		
13	Wearshoe	0.188inches + 0.005 - 0.001	0.193 0.187		
14	Wearshoe	0.375inches ± 0.010	0.385 0.365		
15	Wearshoe	0.063inches ± 0.010	0.073 0.053		

Plex 11/5/19 12:05 PM Dart.lajeunesse.marie

